

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023408**Date Inspected:** 05-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Sun Tian Liang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

OBG Trail Assembly

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint CA3016A-138 located on Corner Assembly RS Stiffener at panel point 124 to 124.5 of Segment 13CW. ZPMC Welder is identified as 066179. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

SMAW welding of weld joint CA3016A-122 located on Corner Assembly RS Stiffener at panel point 123 to 123.5 of Segment 13CW. ZPMC Welder is identified as 067588. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2114-FCM-1.

SMAW welding of weld joint DP3147-001-224 and 223 located on deck panel U-rib splice plate at panel point 123 of Segment 13CW. ZPMC Welder is identified as 045196. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

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SMAW welding of weld joint DP3148-001-113 and 114 located on deck panel U-rib splice plate at panel point 123 of Segment 13CW. ZPMC Welder is identified as 045196. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214—B-U2-FCM-1.

Flux Core Arc Welding (FCAW) welding of weld joint SA3126-002-005 and 006 located on bottom plate connected SA3126 at panel point 123 to 123.5 of OBG Segment 13CW. ZPMC Welder is identified as 045240. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-ESAB.

FCAW welding of weld joint SA3126-008-005 and 006 located on bottom plate connected SA3126 at panel point 123 to 123.5 of OBG Segment 13CW. ZPMC Welder is identified as 058245. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-ESAB.

FCAW welding of weld joint OBG13B-003 located on bottom plate to side plate of OBG Segment 13AW to OBG Segment 13BW. ZPMC Welder is identified as 066421. ZPMC Quality Control (QC) is identified as Mr. Hu Mei Gang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231T-ESAB.

SMAW welding of weld joint SEG3020U-591 located on anchor plate to anchor plate at panel point 126 of OBG Segment 14W. ZPMC Welders are identified as 066361 and 045246. ZPMC Quality Control (QC) is identified as Mr. An Xing Qing. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-4G-(4F)-FCM-Repair-1, which is used as per Critical Welding Repair Report (CWR) B-CWR-2943R0.

SMAW welding of weld joint SEG3020T-100 located on RS stiffener to Floor Beam at panel point of OBG Segment 14W. ZPMC Welder is identified as 066479. ZPMC Quality Control (QC) is identified as Mr. An Xing Qing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3020R-199 located on anchor plate I-rib to floor beam at panel point 126 of OBG Segment 14W. ZPMC Welder is identified as 070432. ZPMC Quality Control (QC) is identified as Mr. An Xing Qing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

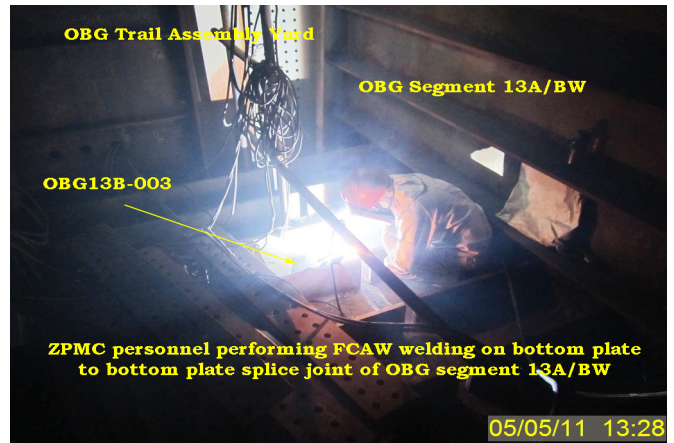
FCAW welding of weld joint FB3315-001-032 located on floor beam at panel point 125 of OBG Segment 14W. ZPMC Welder is identified as 066695. ZPMC Quality Control (QC) is identified as Mr. An Xing Qing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-ESAB.

This QA inspector observed ZPMC personnel performed Magnetic particle Testing (MT) on Deck Panel Diaphragm to Floor Beam Flange Weld at Panel point 122 and 121.5 FL2 Side of OBG Segment 13BW. The weld number is identified as SEG30145H-001 and SEG3014F-351. See the attached picture.

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Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Vibin

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer